

Work Order ID 61542

Monday, August 30, 2010 10:40:01 AM



Page 1

Item ID: D206-559-013

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 8/30/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-8-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-559

PRELIM Rev K

Ph →

100 *70519507*

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG008

*6 per en.
10-613
mk
10-9-15*

8/10/10/12

10-10-8

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

8/10/10/12

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/10/12

(75)

Dart Aerospace Ltd

W/O: 61542		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/12	#100	perm. change update header box to current Rev + include DSZ information Fix CHS # PER EN 10-613	CE	10/10/12			S 10/10/12

Part No: D206-559-013 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61542

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Monday, August 30, 2010 10:40:01 AM

Item ID: D206-559-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 8/30/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PDPD206-559-013 Location: 12 Rev B

10/10/13 SP (S)

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/10/13 MF
10-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 10:40:06 AM

Page 1

Work Order ID: 61542

Parent Item: D206-559-013

Parent Item Name: Bearpaw



Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:J 04.02.17 Blank size changed KJ/JLM
 IPP Rev:K 07-01-02 Was K10008 JLM
 IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
 IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A	Per DSZ 95278, 10110112	Purchased	No			160	Each	375.0000	12	60			Pto →
---------	-------------------------	-----------	----	--	--	-----	------	----------	----	----	--	--	-------



Bolt

Location	Loc Qty	Loc Code
ST	112	
115374	112	
ST338	112	
ST358	263	
114784	21	
115108	142	
115371	100	

AN4-17A		Purchased	No			160	Each	536.0000	12	60			
---------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--



Bolt

Location	Loc Qty	Loc Code
ST359	536	
112314	536	

AN20601D416	NAS1149D0463J	Purchased	No			160	Each	0.0000	24	120			
-------------	---------------	-----------	----	--	--	-----	------	--------	----	-----	--	--	--



Washer

M112314

M1116

M115647

10/10/12 (5)

W/O: 61542		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/10/12	#100	Perm. change update change of belts + A14-20A per DS2 9522. #12 per kit	BC	10/10/12			S 10/10/12	

Part No: D206-559-013 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 61542

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 5.00

Required Qty: 5.00

D2182B

Manufactured No

160 f

215.1285 2.5 12.5



Rubber Cushion



Handwritten signature

Location

Loc Qty

Loc Code

ST402A

26.07

30872

13.67

39986

12.4

ST410

189.05854

52649

189.05854

52649

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274

Manufactured No

160 Each

168.0000 12 1 60



Radius Block



Handwritten signature

Location

Loc Qty

Loc Code

ST010

168

59108

168

59108

D2432

Manufactured No

160 Each

0.0000 2 10



206 (24") Bearpaw



61535

D2438

Manufactured No

160 Each

228.0000 6 30



Clamp



Handwritten signature

Location

Loc Qty

Loc Code

ST456

228

59123

28

60852

200

*59123 9p
60852 21p*

(5)

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61542

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 5.00

Required Qty: 5.00

D2529

Manufactured No

160 Each

166.0000

12 60

Washer

Location

Loc Qty

Loc Code

ST017

166

58568

166

58568

D2732

Manufactured No

160 f

253.6157

2.5

12.5

Rubber Extrusion

Location

Loc Qty

Loc Code

ST412

253.615737

56516

253.615737

56516 1.0 X 93118 2.00

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

MS21042L4

Purchased No

160 Each

2,527.000

12

60

cut

Location

Loc Qty

Loc Code

ST300

2527

113422

68

114523

28

114718

16

114784

495

115108

1920

115108

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST (D206-559 REV. K)
32.7 PARTS LIST (ICA-D205-559 REV. 2)






Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.30
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
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